

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016556**Date Inspected:** 22-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint WSD1-SPSA5-20-2A located on PCMK west tower, lift 5, internal splice plate assembly. Welder was identified as 202100. QC was identified as ZPMC CWI Yu Dong Ping (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-T-3212-TC-U5b-1.

SMAW welding of weld joint WSD1-TL5-4B/F-13A located on PCMK west tower, lift 5, external connection plate to skin A. Alternating welders were identified as 037780, 037743. QC was identified as ZPMC CWI Liu Yang (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW welding of weld joint WSD1-TL5-4B/F-17A located on PCMK west tower, lift 5, external connection plate to skin A. Alternating welders were identified as 060763, 066418. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U5b.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 5 )

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SMAW welding of weld joint WSD1-TL5-4B/F-4 located on PCMK west tower, lift 5, internal connection plates. Alternating welders were identified as 066413, 067656. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint WSD1-TL5-4B/F-24 located on PCMK west tower, lift 5, internal connection plates. Alternating welders were identified as 066398, 066401. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint ESD1-TL5-2B/F-19 located on PCMK east tower, lift 5, internal connection plates. Alternating welders were identified as 044541, 040724. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint ESD1-TL5-2B/F-14 located on PCMK east tower, lift 5, internal connection plates. Alternating welders were identified as 046704, 040611. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint ESD1-TL5-2B/F-4A located on PCMK east tower, lift 5, external connection plate to skin A corner. Welder was identified as 040723. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-3213-TC-U5b.

### Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint SSD1-TL5-1B-F-15 located on PCMK south tower, lift 5, internal connection plates. Alternating welders were identified as 057259, 057266. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Yuan Hui Gang (QCA2), who was not a CWI. Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint SSD1-TL5-1B-F-20 located on PCMK south tower, lift 5, internal connection plates. Alternating welders were identified as 044504, 040312. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QC2 appeared to comply with WPS-B-T-3213-TC-U4c.

SMAW welding of weld joint SSD1-TL5-1B-F-4A located on PCMK south tower, lift 5, external connection plate to skin A. Welder was identified as 056200. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3313-TC-U5b.

SMAW welding of weld joint SSD1-TL5-1B-F-8B located on PCMK south tower, lift 5, external connection plate

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## WELDING INSPECTION REPORT

( Continued Page 3 of 5 )

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to skin A. Welder was identified as 057220. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3313-TC-U5b.

SMAW welding of weld joint SSD1-TL5-1B-F-18 located on PCMK south tower, lift 5, external connection plate to skin A. Alternating welders were identified as 057258, 040273. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QCA2, who was not a CWI. Welding variables recorded by QCA2 appeared to comply with WPS-B-T-3313-TC-U5b.

SMAW welding of weld joint NSD1-TL5-3B-F-21B located on PCMK north tower, lift 5, external connection plate to skin A. Alternating welders were identified as 066258, 066361. QC was identified as ABF CWI Yang Yi Heng (QC3). Welding variables recorded by QC3 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW welding of weld joint NSD1-TL5-3F-F-16A located on PCMK north tower, lift 5, connection plates. Alternating welders were identified as 070432, 067588. QC was identified as QC3. Welding variables recorded by QC3 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW welding of weld joints NSD1-TL5-3B-F-16B located on PCMK north tower, lift 5, internal connection plates. Alternating welders were identified as 037996, 066155. QC was identified as QC3. Welding variables recorded by QC3 appeared to comply with WPS-B-T-3213-TC-U5b.

SMAW welding of weld joint NSD1-TL5-3B-F-15 located on PCMK north tower, lift 5, internal connection plate to skin A. Alternating welders were identified as 067707, 066416. QC was identified as QC3. Welding variables recorded by QC3 appeared to comply with WPS-B-T-3213-TC-U4c.

### Heavy Dock

This QA Inspector randomly observed the following work being performed on the Heavy Dock:

This QA Inspector observed no apparent work was being performed on the Heavy Dock. All 4 tower lift's 3 were connected and positioned vertically on a base pedestal at end of the heavy dock. West tower, lift 2 was positioned horizontally near the end of the Heavy Dock and north tower, lift 2 was being transported down the dock on 4 Goldhofer lift vehicles. The ZPMC 2200 ton floating crane was moored to the end of the Heavy Dock and sitting idle.

### Bay 9 – PMT

This QA Inspector monitored OBG Production Monitoring Test (PMT) #3163 for deck panels 14W-DP3163(PL3439A/B)-001 and 14W-DP3167(PL3436A/B)-001 at Gantry #1. Prior to the start of the PMT, this QA Inspector observed the root openings to be within the 0.0mm to 0.5mm tolerance. The magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Technician Wang Wei on 8/22/10. The visual inspection of tack welds and root gaps was performed by ABF CWI Huang Wen Guang (PABF) and this QA Inspector. The tack welds and root gaps appeared to be within prescribed tolerances. This QA Inspector observed that the deck plate of the test panel was 20mm thick and the deck plate of the production panels were 20mm thick. This QA Inspector observed that the test panel was generally representative of the production panels. The ambient temperature was approximately 30°C. Welders were identified respectively,

# WELDING INSPECTION REPORT

( Continued Page 4 of 5 )

from position 1 through 6, respectively, as follows: 059418, 059421, 059443, 201788, 059403, 059416. ZPMC personnel used an oxy-fuel torch to preheat the specimens to above 60°C and the interpass temperature was still above 60°C without additional heating, in conformance with WPS-B-T-2342-U1-(U-rib)-5. See photos below. The start time for welding of the 3–12mm x 20mm specimens was approximately 0015 hours on 8/23/10 and the finish time was approximately 0138 hours. This QA Inspector randomly verified and documented the welding amperage, voltage, and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The welding variables recorded by PABF appeared to comply with WPS-B-T-2342-U1-(U-rib)-5. The welds were visually inspected by PABF and this QA Inspector. PABF informed this QA Inspector that all six welds were acceptable and after random inspection this QA Inspector concurred. This QA inspector randomly witnessed ZPMC ultrasonic testing (UT) inspector, identified as Xu Wei, perform UT on each of the 500 mm test welds for depth of penetration and conformance. This QA Inspector selected fifteen designated locations for macroetch sampling per contract requirements. Each macroetch sample location was stamped by ZPMC personnel with the number 3163, a number 6, chosen randomly by this QA Inspector as a verification mark, and an individual progressive macroetch identifying number for each macroetch sample. See photos below. After removal from each of the weld test specimens, polishing, and acid etching of the selected end, the macroetch samples were evaluated using a 7X optical magnifier and accepted by PABF and this QA Inspector.

All fifteen sample macroetch samples appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC Production Monitoring Test Plate Inspection Report, and Caltrans Macro Etch Log - all dated 8/23/2010 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

As noted above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Dawson, Paul	QA Reviewer
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